

Work Order ID 145033

Friday, April 29, 2016 1:54:36 PM

145033

Page 1

Item ID: D412-760-111

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 5/2/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: dm Date: 16/04/29 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN D412-760	G			DAS 6					
100	Document Control	0.00		9-89					

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-760-111 CHG002

DAS
27
9-89
MAY 11 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS DAS
8 28
9-89 9-89
MAY 08 2016

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

DAS
27
9-89
MAY 11 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 145033

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145033

Page 2

Item ID: D412-760-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 5/2/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-760-011
Location:FG040

DAS

27

9-89

MAY 11 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

MC

MAY 11 2016

MC

MAY 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																								OTHER :																																							

Picklist Print

Friday, April 29, 2016 1:54:41 PM

Page 1

Work Order ID: 145033

145033

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 5/2/2016

Required Date: 5/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.19 per ecn10-646 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3933-1 Aft Wall Protector, DAS 27		Manufactured	No			110	Each	0.0000	1	1		DAS 6 9-89	DAS 28 9-89
D3933-1									**	14268			
D3933-2 Aft Wall Protector, RH, DAS 27		Manufactured	No			110	Each	0.0000	1	1		DAS 6 9-89	DAS 28 9-89
D3933-2									**	142722			
D3935-1 Pylon Wall Protector, LH, DAS 27		Manufactured	No			110	Each	0.0000	1	1		DAS 6 9-89	DAS 28 9-89
D3935-1									**	142692			
D3935-2 Pylon Wall, DAS 27		Manufactured	No			110	Each	0.0000	1	1		DAS 6 9-89	DAS 28 9-89
D3935-2									**	142714			
D3942-1 Angle, DAS 27		Manufactured	No			110	Each	30.0000	14	14		DAS 6 9-89	DAS 28 9-89
D3942-1									**				
D3942-3 Clip, DAS 27		Manufactured	No			110	Each	10.0000	10	10		DAS 6 9-89	DAS 28 9-89
D3942-3									**				
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST060	30								
				140519	30								
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST060	10								
				140522	10								

MAY 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Work Order ID: 145033

145033

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 5/2/2016

Required Date: 5/5/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-10

Purchased

No

110

Each

44.0000

4

4

MS27039-4-10

Screw

**

DAS

28

9-89

Location

Loc Qty

Loc Code

ST279

44

m131885

44

4

MS27039-4-14

Purchased

No

110

Each

0.0000

6

6

MS27039-4-14

SCREW

**

134702

DAS

28

9-89

MS27039-5-08

Purchased

No

110

Each

3.0000

6

6

MS27039-5-08

Screw

**

134719 X3

DAS

28

9-89

Location

Loc Qty

Loc Code

ST279

3

m134039

3

3

MS27039-5-12

Purchased

No

110

Each

29.0000

8

8

MS27039-5-12

Screw

**

MAY 08 2016

Location

Loc Qty

Loc Code

ST278

29

m133694

5

m134502

4

m134676

20

4
4
4

DAS
28
9-89

DAS

28

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Qty -111	Qty -113	Part Number	Description
X		D412-760-111	AFT CABIN WALL AND PYLON PROTECTOR KIT
	X	D412-760-113	AFT CABIN WALL AND PYLON PROTECTOR KIT
1	1	D3933-1	LH AFT CABIN WALL PROTECTOR
1	1	D3933-2	RH AFT CABIN WALL PROTECTOR
1		D3935-1	LH PYLON PROTECTOR
1		D3935-2	RH PYLON PROTECTOR
	1	D3935-3	LH PYLON PROTECTOR
	1	D3935-4	RH PYLON PROTECTOR
14	14	D3942-1	ANGLE
10	10	D3942-3	CLIP
4	4	MS27039-4-10	SCREW
6	6	MS27039-4-14	SCREW
6	6	MS27039-5-08	SCREW
8	8	MS27039-5-12	SCREW

Qty -211	Qty -213	Qty -215	Qty -217	Part Number	Description
X				D412-760-211	BAGGAGE COMPARTMENT PROTECTOR KIT
	X			D412-760-213	BAGGAGE COMPARTMENT CEILING PROTECTOR KIT
		X		D412-760-215	CARGO FLOOR PROTECTOR KIT
			X	D412-760-217	LIGHTWEIGHT BAGGAGE COMPARTMENT PROTECTOR KIT
36	7	8		D3628-1	CUPPED WASHER
			43	D3628-5	CUPPED WASHER
1				D3876-1	RH FORWARD WALL PROTECTOR
1				D3876-3	FORWARD WALL PROTECTOR
1				D3876-5	LH WALL PROTECTOR
1				D3876-7	AFT WALL PROTECTOR
1				D3876-9	RH AFT WALL PROTECTOR
1		1		D3876-11	FLOOR PROTECTOR
1				D3876-13	DOOR PROTECTOR
1		1		D3952-1	PLACARD
			1	D3952-3	PLACARD
	1			D4438-1	CEILING PROTECTOR
			1	D4640-1	RH FWD WALL PROTECTOR
			1	D4640-3	FORWARD WALL PROTECTOR
			1	D4640-5	LH WALL PROTECTOR
			1	D4640-7	AFT WALL PROTECTOR
			1	D4640-9	RH AFT WALL PROTECTOR
			1	D4640-11	FLOOR PROTECTOR
			1	D4640-13	DOOR PROTECTOR
			1	D4640-15	CEILING PROTECTOR
36		8	36	80-004-2-6	INSERT
	7		7	80-004-2-8	INSERT
36		8	36	MS27039-1-04	SCREW
	7		7	MS27039-1-05	SCREW
	3		3	MS27039-1-10	SCREW
	6		6	NAS1149F0363P	WASHER (AN960-10)

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Revision: G

Date: 13.01.03